



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3403-1
Job Sheet 178419



Part No: D3403-1

Job Qty: 40 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/8/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3403 REV F IPP Rev:A 05.08.31 New issue KJ/JLM IPP Rev:B 06-03-07 As per Rev B JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	40 Ea	6/8/18	6/8/18	0.00	0.00	Start Up Machining-2		JRD 16/7/15
100	Hardinge	40 pcs	6/8/18	6/8/18	0.08	5.14	Hardinge		JRD 16/7/15
120	QC	40 pcs	6/8/18	6/8/18	0.00	0.00	QC8		JRD 16/7/15
130	Packaging	40 pcs	6/8/18	6/8/18	0.00	0.00	Packaging3-1		JRD 16/7/15
140	QC21-SA	40 Ea	6/8/18	6/8/18	0.00	0.00	QC21		JRD 16/7/15

Part Op
Descriptions: 100 - 1- Turn as per Folio FA556 & Dwg D3403 Folio Rev: _____ Dwg Rev: _____

DAS 53 9-89 JUL 16 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.750	303 Round Bar 0.750	8.6800 ft (.217 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R0.750	9	71	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	2.360inches + 0.010 - 0.000	2.370 2.360		
2	Bushing	0.060inches ± 0.005	0.065 0.055		
3	Bushing	0.257inches + 0.010 - 0.000	0.267 0.257		
4	Bushing	0.750inches ± 0.010	0.760 0.740		
5	Bushing	0.425inches + 0.000 - 0.002	0.425 0.423		
6	Bushing	0.030inches ± 0.010	0.040 0.020		
7	Bushing	20.0Degrees ± 0.5	20.5 19.5		
8	Bushing	0.313inches ± 0.010	0.323		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

			0.303
9	Bushing	60.0Degrees ± 0.5	60.5 59.5

Plex 5/31/18 12:44 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

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